

Date: Tuesday, 11/14/2006 10:03:48 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR PROTECTOR FWD RH  
 Job Number : 29425  
 Estimate Number : 11234  
 P.O. Number : N/A Part Number : D32812  
 This Issue : 11/14/2006 S.O. No. : N/A Drawing Number : D3281 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B  
 Previous Run : 27509 Material : N/A  
 Due Date : 12/20/2006 Qty: 10 Um: Each  
 Written By : [Signature]  
 Checked & Approved By : [Signature] 06.11.14  
 Comment : Est Rev:A 04.07.01 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2495

C20011115

Description: Floor Protector Fwd, RH

Possible Supplier: Delastek

Certificate of Conformity is required

(10)

2.0 D32812P Floor Protector, Fwd RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
 Floor Protector Fwd, RH

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

PU 4/12/22 (10)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

07.01.03 (10)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Packaging area PB 07/10/03 (10)

over

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 07/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/14/2006 10:03:48 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD RH

Job Number: 29425

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

A 07.01.04

Job Completion



CL07/01/04

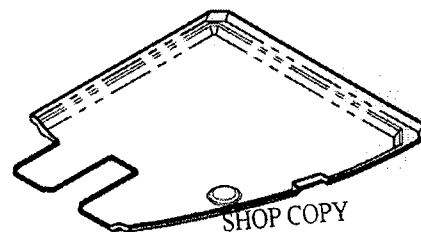
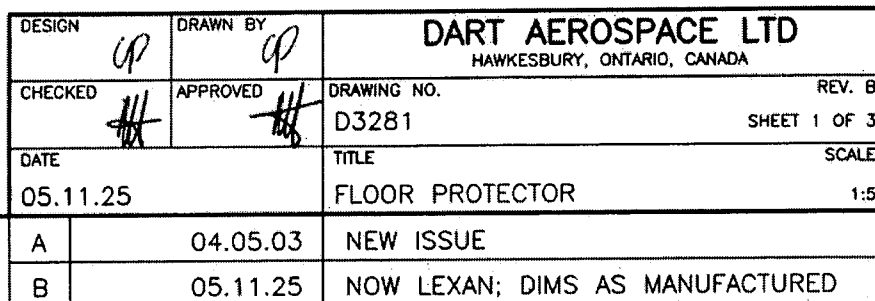
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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JECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
O. 29425

D3281-1 FLOOR PROTECTOR, FWD LH

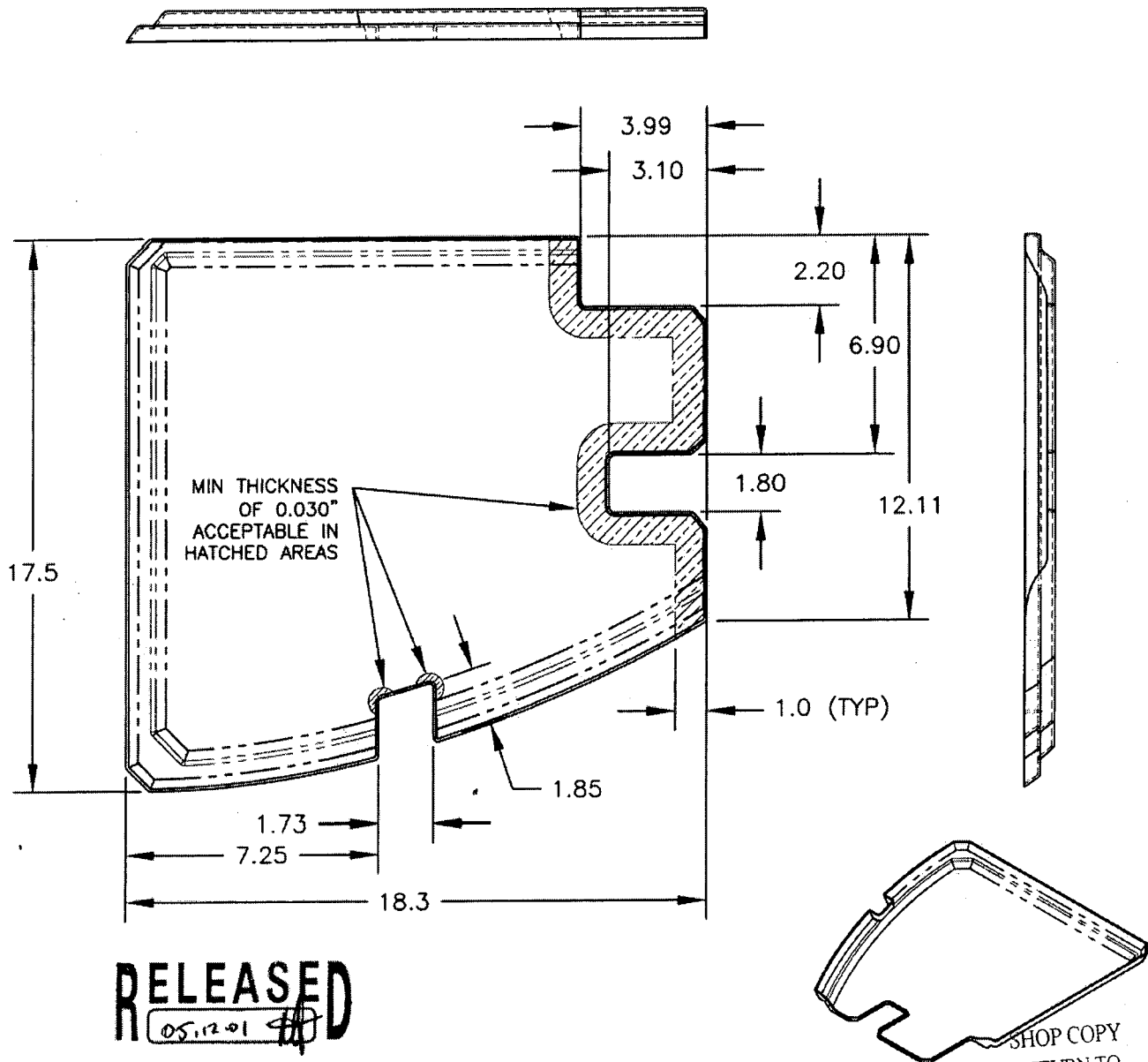
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**D3281-2 FLOOR PROTECTOR. FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

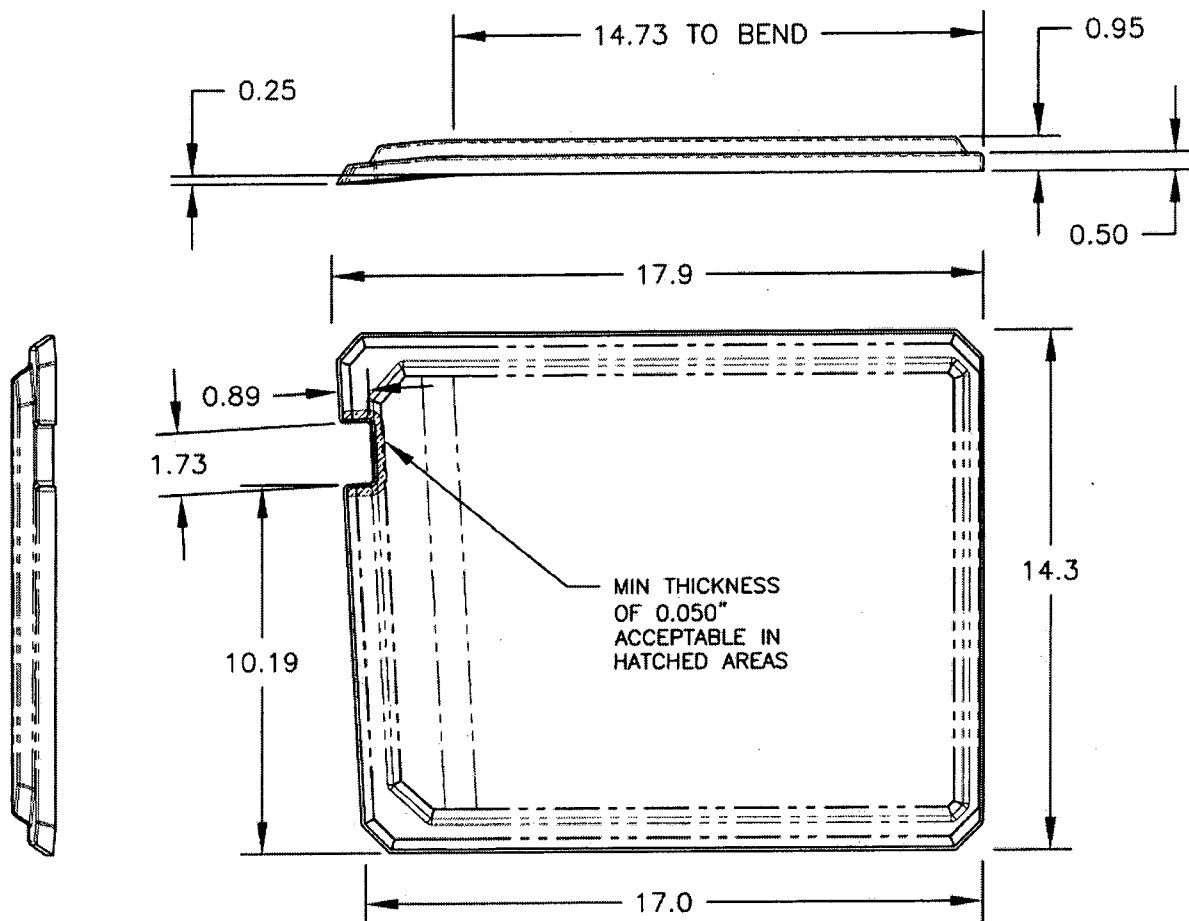
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NO. 29425

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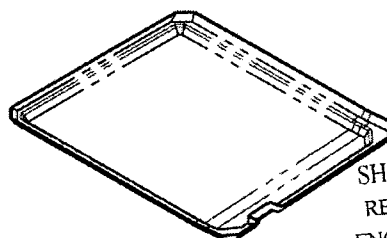
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DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



RELEASED  
05.2.01. *[Signature]*



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WORK ORDER  
NO. 29425

**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**  
**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2  
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11463
Customer #	DART

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #		GST/PST #
21/12/06	15/11/06	5017	C. Lavoie		P000002495		
Order Qty	B.O. Qty	Current Ship	Item #	Item Description			
10	0	(10)	DKC134-0045	Floor Protect Part 2 N° D3281-2 ( F6006 ) B29425 ✓ Selon dessin D3281 Rev.: B Job: 38794 ✓ U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Mardi, 2006-09-12 13:20:34

Mars Dubé

## Feuille de Procédé

nt	: DART	Dart Aerospace Ltd.	Nom Dessin	: FLOOR PROTECTOR	
néro Job	: 38794		Numéro Article	: DKC134-0045	
néro Soumission	: 2384		Numéro Dessin	: D3281	
néro B.A.	:		Projet Numéro	: DKC134	
le fois	: 2006-09-12	No. B.V. :	Révision dessin	: B	
ht Rev.	: NC		Matériel	: F6006	
m. fois	: - -	Type :	Date Dûe	: 2006-09-19	Qté: 15
précédente	: 36893				UdM: UNITE

it par : \_\_\_\_\_  
 ifié & Approuvé par : \_\_\_\_\_  
 nimentales : N° de pièce: D3281-2



Process Sheet Rév.: 00 Création du premier

duit additionnel

néro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Total : 4.509 UNITE(s)

Lexan F

APL0002

N° de L:



2.0	SÉCHAGE/	Polycarb F6006 48x96x 0.080" Gris #GY21088
		# Lot: 3-5163-8 Expir:



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.9000Hrs

SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

# de cuisson: 5286

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 81.0000Hrs

TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:














24" x 26" x .125" Thk.

Quantité: 15 Date: 13-10-06 Sceau: \_\_\_\_\_


Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_






12ccp.


# Séq.:	Machine ou Opération:	Description :
4.0	THERMOFORMAGE2 	THERMOFORMAGE DES PIÈCE DART 
<p>Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 4.5000Hrs THERMOFORMAGE DES PIECES</p> <p>Faire le thermoformage du " Floor Protector " N° D3281-2 à l'aide du moule N° D3281-2T1 sur le thermoformeur 4' x 8'.</p> <p>Autocontrôle du lot de pièce thermoformées.</p> <p>Quantité: <u>15</u> Date: <u>13-09</u> Sceau:  <i>F.O: 13 sept 06</i>  <i>manque de matériel</i></p> <p>Quantité: _____ Date: _____ Sceau: _____</p>		
5.0	TRIMAGE 3 	TRIMAGE COMPOSITES DART 
<p>Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 4.5000Hrs TRIMAGE PLASTIQUE DART</p> <p>Faire le trimage du " Floor Protector " N° D3281-2 à l'aide du gabarit de trimage N° D3281-2T2.</p> <p>Faire l'ébavurage des pièces.</p> <p>Autocontrôle du lot de pièce trimées.</p> <p>Quantité: <u>14</u> Date: <u>14-09</u> Sceau:  <i>F.O: 13 sept 06</i>  <i>rejet / méthylene identifie sloof</i></p> <p>Quantité: _____ Date: _____ Sceau: _____</p>		
6.0	INSPECTION 3 	INSPECTION PIÈCE DART 
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 2.2500Hrs INSPECTION PIÈCE DART</p> <p>Faire l'inspection finale des pièces selon le dessin.</p> <p>Quantité: <u>14</u> Date: <u>14 sept 06</u> Sceau: </p>		
7.0	IDENTIFICATION4 	IDENTIFICATION PIÈCES DART 
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 2.2500Hrs IDENTIFICATION PIÈCES DART</p> <p>Faire l'identification des pièces à l'aide des informations suivantes:</p>		

# Feuille de Procédé

Client: DART Dart Aerospace Ltd.	Nom Dessin: FLOOR PROTECTOR
Numéro Job: 38794	Numéro Article: DKC134-0045
uméro Job:	

# Séq.:	Machine ou Opération:	Description :
	N° de pièce: D3281-2 N° de Job: _____ Date de fabrication: _____ Sceau d'inspection.	
	Quantité: <u>14</u> Date: <u>14-09-06</u> Sceau: 	
	Quantité: _____ Date: _____ Sceau: _____	

8.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE
		

<b>Commentaire</b> Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 2.2500Hrs EMBALLAGE ET ENTREPOSAGE  Emballer les pièces individuellement dans un sac en platique et ensuite mettre dans une boîte en carton identifiée comme suit:  N° de pièce: D3281-2 Date de fabrication: _____ N° de job: _____ Quantité: <u>14</u> Date: <u>14/9/06</u> Sceau:  Quantité: _____ Date: _____ Sceau: _____
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